



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 186789



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Large Fab-5		C 12-28-18
100	Large Fab	1 pcs		12/7/18	0.00	10.00	Large Fab 1		C 12-28-18
110	QC	1 pcs		12/7/18	0.00	0.00	QC9		
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		
125	HandFinish	1 pcs		12/7/18	0.00	0.29	HandFinish2		DK 19-01-7
130	Powdercoat	1 pcs		12/7/18	0.00	0.93	Powdercoat2		DK 19-01-7
135	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging1		DEB 19-01-08
140	QC	1 pcs		12/7/18	0.00	0.00	QC3		DEB 19-01-08
150	HandFinish	1 pcs		12/7/18	0.00	0.50	HandFinish4		DEB 19-01-08
160	QC	1 pcs		12/7/18	0.00	0.00	QC5		JAN 08 2019 68
170	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3-2		DEB 19-01-08
180	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		21 JAN 08 2019

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

IN 18951 START: 2:05 OUT: 3:45 FINISH: 2:20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	5125 289
D3913-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5123 779
D3913-15 ✓	Wide Handle Plate	1 Ea (1 ea) ✓	90-Start up Operation	5115 269
D3913-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5124 101
D3913-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5130 111
D3913-9 ✓	Hinge Rib	1 Ea (1 ea) ✓	90-Start up Operation	5133 177
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5132 262
D3916-5 ✓	Light Rib	3 Ea (3 ea) ✓	90-Start up Operation	1x5133 015 / 2x5137 213
D4016-1 ✓	Hinge Half, Base	3 Ea (3 ea) ✓	90-Start up Operation	5112 356
D4017-7 ✓	Rib	3 Ea (3 ea) ✓	90-Start up Operation	5123 991
D4017-9 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5134 676

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd. 1270 Aberdeen Street Hickesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 12/28/10 DART AEROSPACE Container No: S140685 Part: D3913 - 041 Job No: 186789 Serial No/Batch: S140685 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/28/10		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																															
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D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	1x 5133429
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5126559
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5131344
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5132095
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5126705
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5109214
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5106952
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	586435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5133206-1
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5118039
NAS1149F0332P Washer		2 Ea	150-HandFinish	5136368-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	58	0
	D3913-1	1	8	0
	D3913-15	1	12	0
	D3913-3	1	8	0
	D3913-7	2	10	0
	D3913-9	1	5	0
	D3916-041	2	8	0
	D3916-5	3	9	0
	D4016-1	3	196	0
	D4017-7	3	38	0
	D4017-9	2	8	0
	D4020-11	2	13	0
	D4021-1	3	36	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	24	0
	M304EX0.75-16F	33	2,292	0
	AN3-10A	6	150	0
	D2931	2	912	0
	D4021-5	2	25	0
150-HandFinish	MS20600-AD4W3	2	303	0
	MS21042L3	6	1,588	0
	NAS1149F0332P	12	865	0

Part Specifications

Specifications could not be found.

Plex 11/21/18 10:48 AM Dart.lajeunesse.marie

007237

DQA: _____ Date: _____

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